

Date: Monday, 04/05/2009 1:45:12 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : VERTICAL TUNNEL R/H
<b>Job Number</b> : 47672B	
<b>Estimate Number</b> : 13586	
<b>P.O. Number</b> :	<b>Part Number</b> : D38222 <b>GY</b>
<b>This Issue</b> : 04/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3822-2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 47304B	<b>Material</b> : MKYD6185S080P362015
<b>Written By</b> :	<b>Due Date</b> : 11/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09-05-04</u>	<b>29</b>
<b>Comment</b> : Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD	



## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey



*MD 09/05/15*



**Comment:** Qty.: 7.4028 sf(s)/Unit Total : 7.4028 sf(s)  
6185 Kydex .080"

*M 111807*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

*BB 09/05/20*

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

*BB 09/05/20 (X2)*

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-2 and folio FTA 026 using tool DT 9074

Dwg. Rev. B  
Folio Rev. B

*BB 09/05/20 (X2)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 04/05/2009 1:45:12 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL R/H

Job Number: 47672B

Part Number: D38222

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/21 x2  
(x2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09.05.21

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09.05.21

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DL 09.05.21

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

POSS (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: PDP 47672

POSITIVE RECALL

EFFECTIVE

AUTH

USED

DATE

09/05/20

09/05/25

09/05/26 (x2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 09-05-25

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD	Work Order:	47672B
Description:	Part Number:	3822-2
Inspection Dwg: 03822-2 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4"</u> <i>N/A</i>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

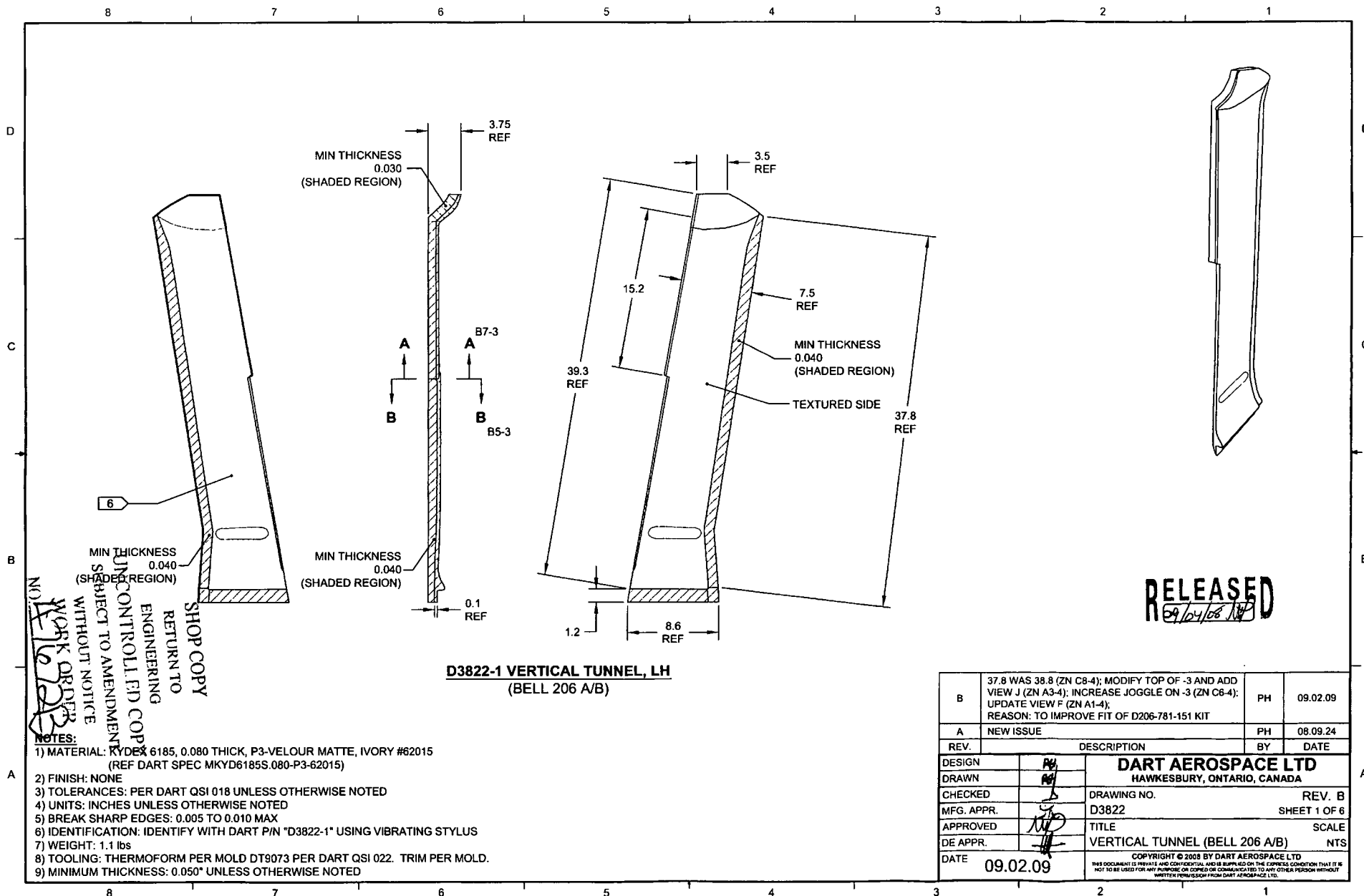
Measured by: <u>B</u>	Date: <u>09/05/21</u>
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### TRIMMING SECTION

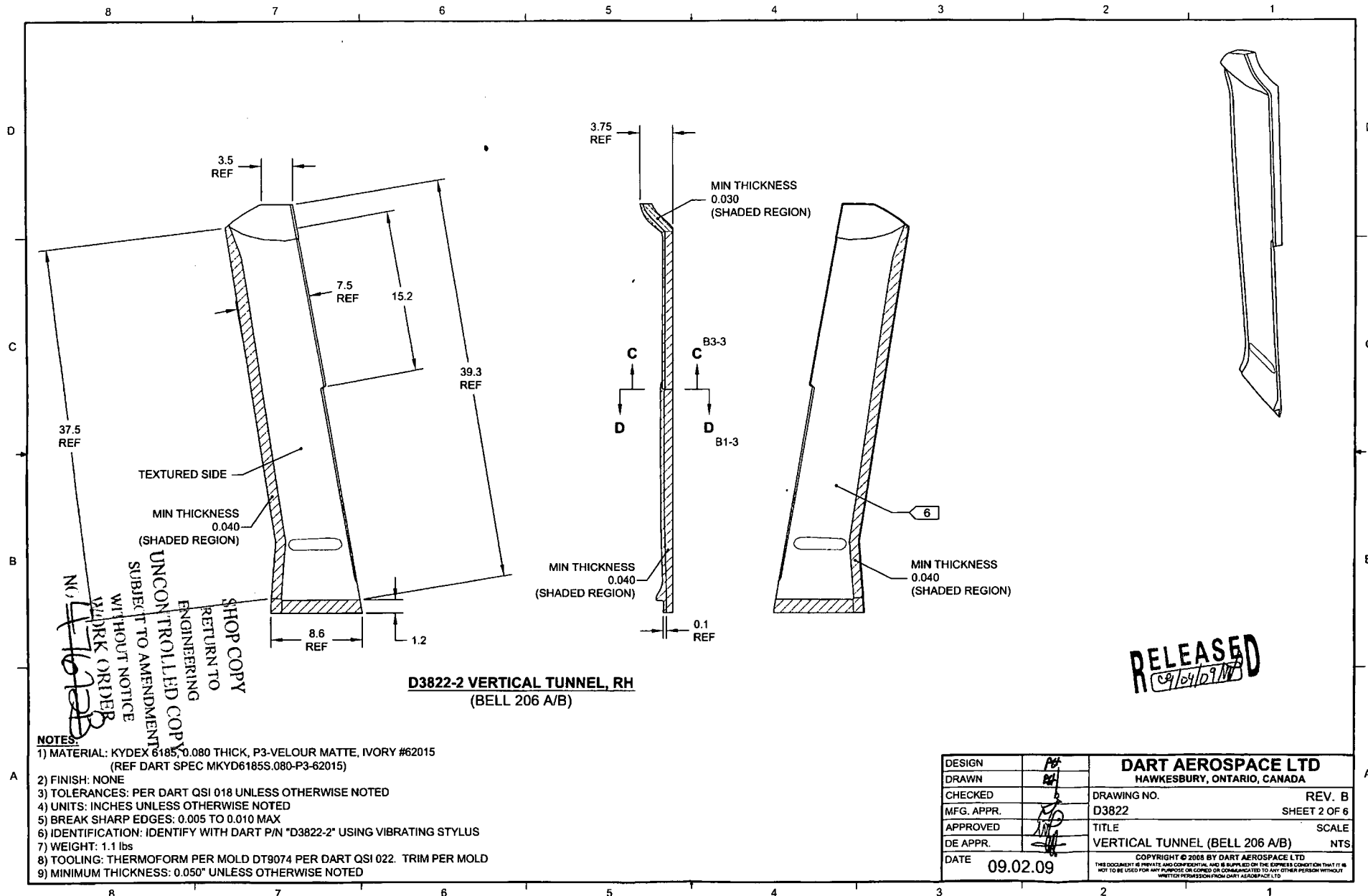
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	MIN	0.9	✓			
0.55	MIN	0.61	✓			
0.3	MIN	0.347	✓			
0.030	MIN	0.46	✓			
0.040	MIN	0.053	✓			
1.2	± 0.100	1.2	✓			

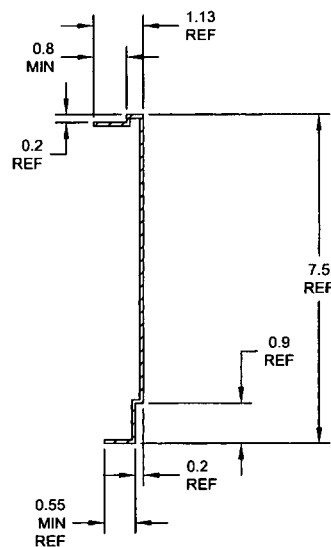
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Audited by: <u>[Signature]</u>	Date: <u>090525</u>
Prototype Approval: <u>[Signature]</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



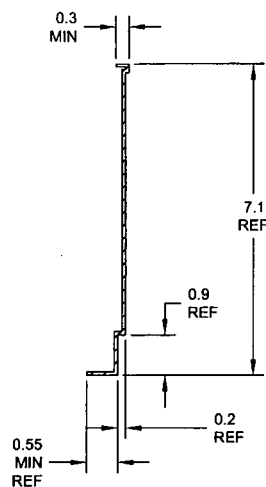
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C8-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA		
CHECKED	PA		
MFG. APPR.	PA		
APPROVED	PA		
DE APPR.	PA	<b>VERTICAL TUNNEL (BELL 206 A/B)</b> SCALE NTS	
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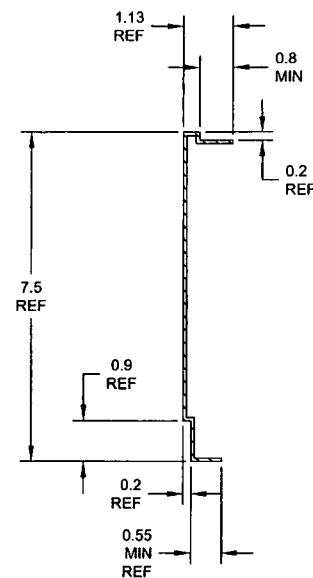
**SECTION A-A**

C6-1



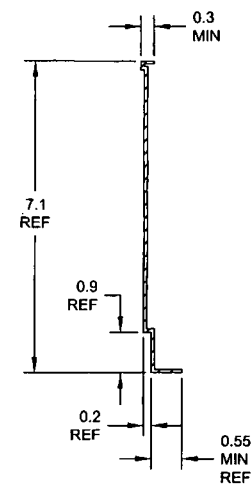
**SECTION B-B**

C6-1



**SECTION C-C**

C4-2



**SECTION D-D**

C4-2

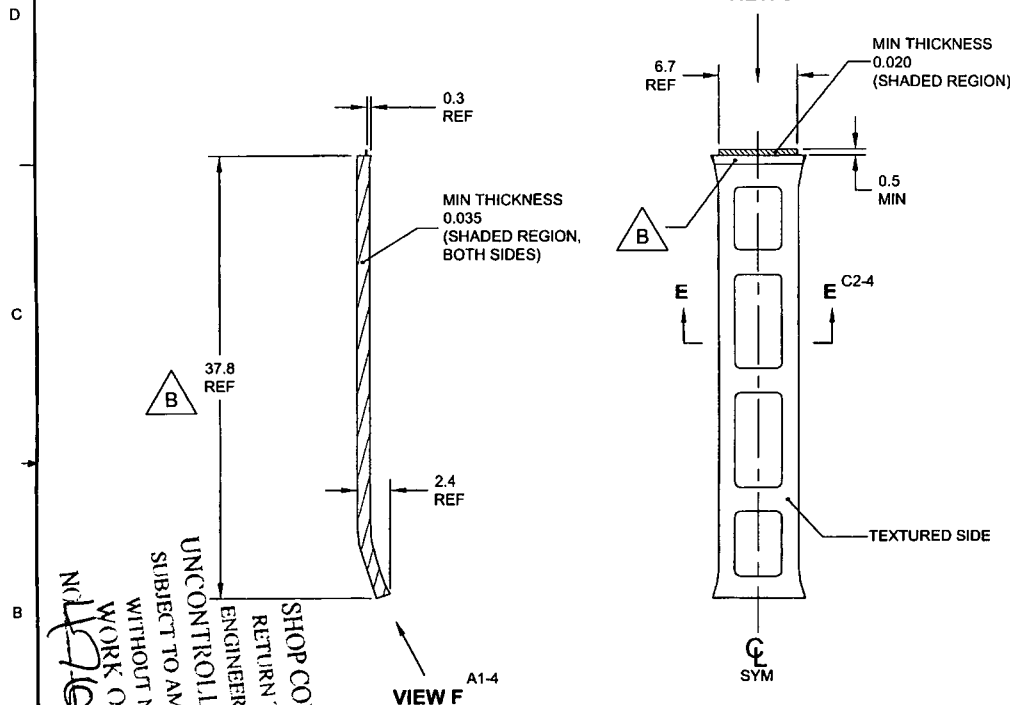
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RETURN TO  
SHOP COPY

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DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	PA	D3822	SHEET 3 OF 6
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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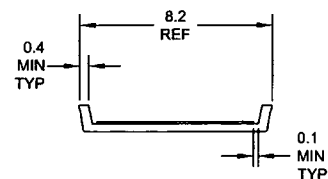


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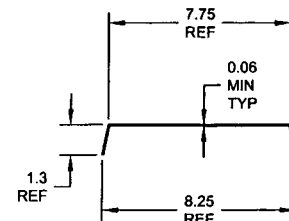


**D3822-3 VERTICAL TUNNEL, AFT CENTER**  
(BELL 206 A/B)

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
  - 7) WEIGHT: 1.1 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD.
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



**VIEW J**  
SCALE 2X

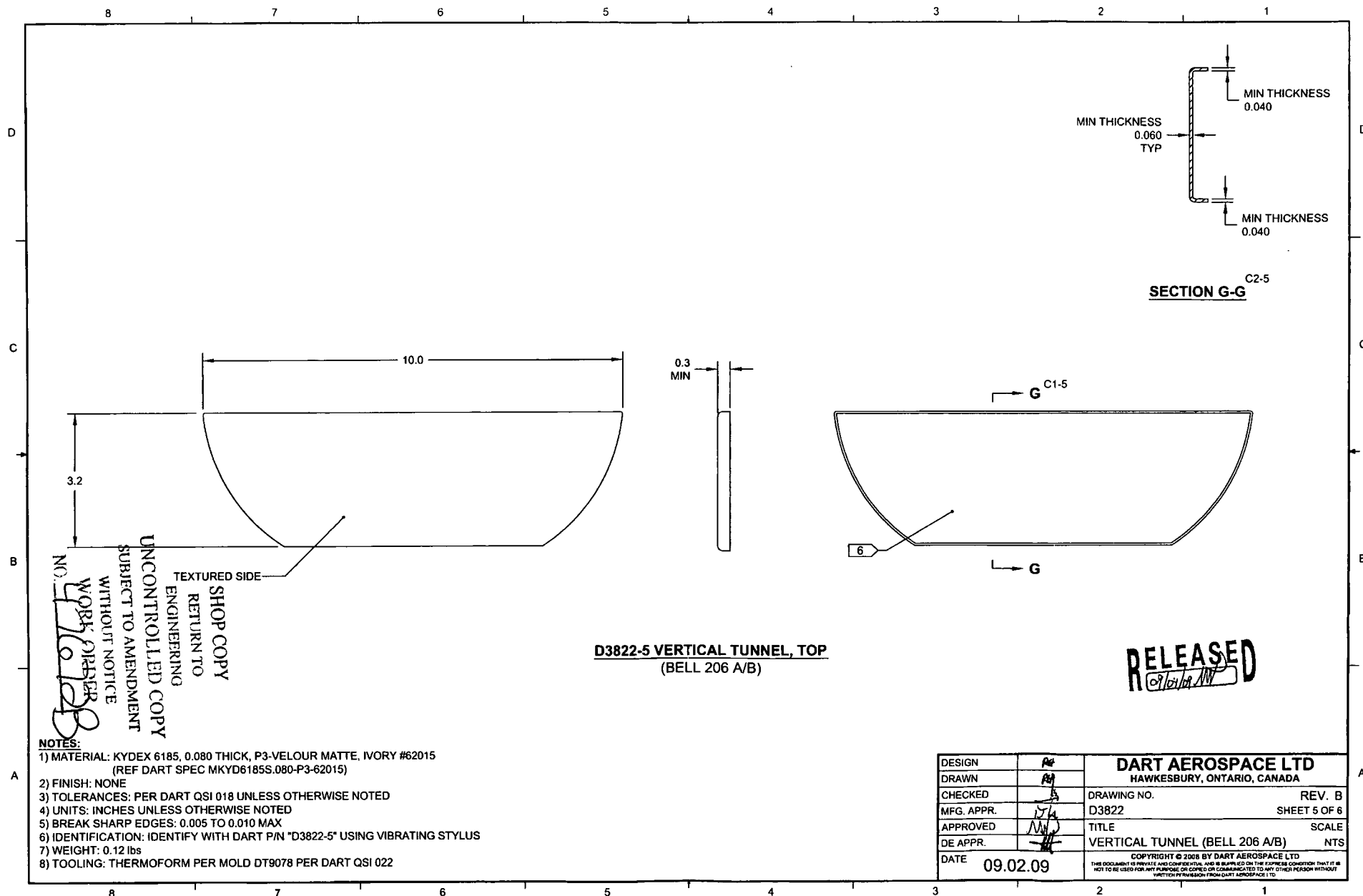


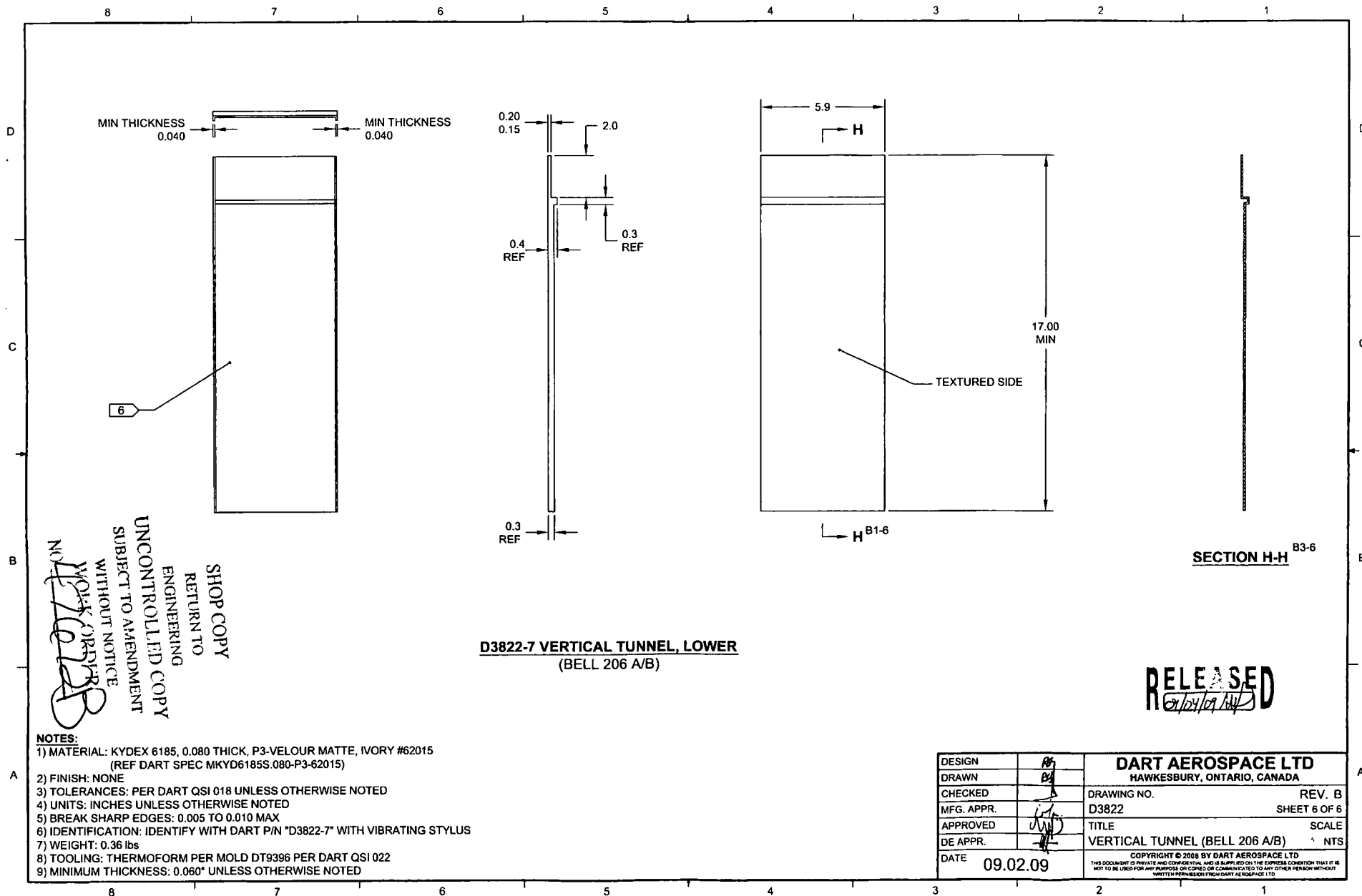
**VIEW F**  
SCALE 2X  
(ROTATED 90° CW)

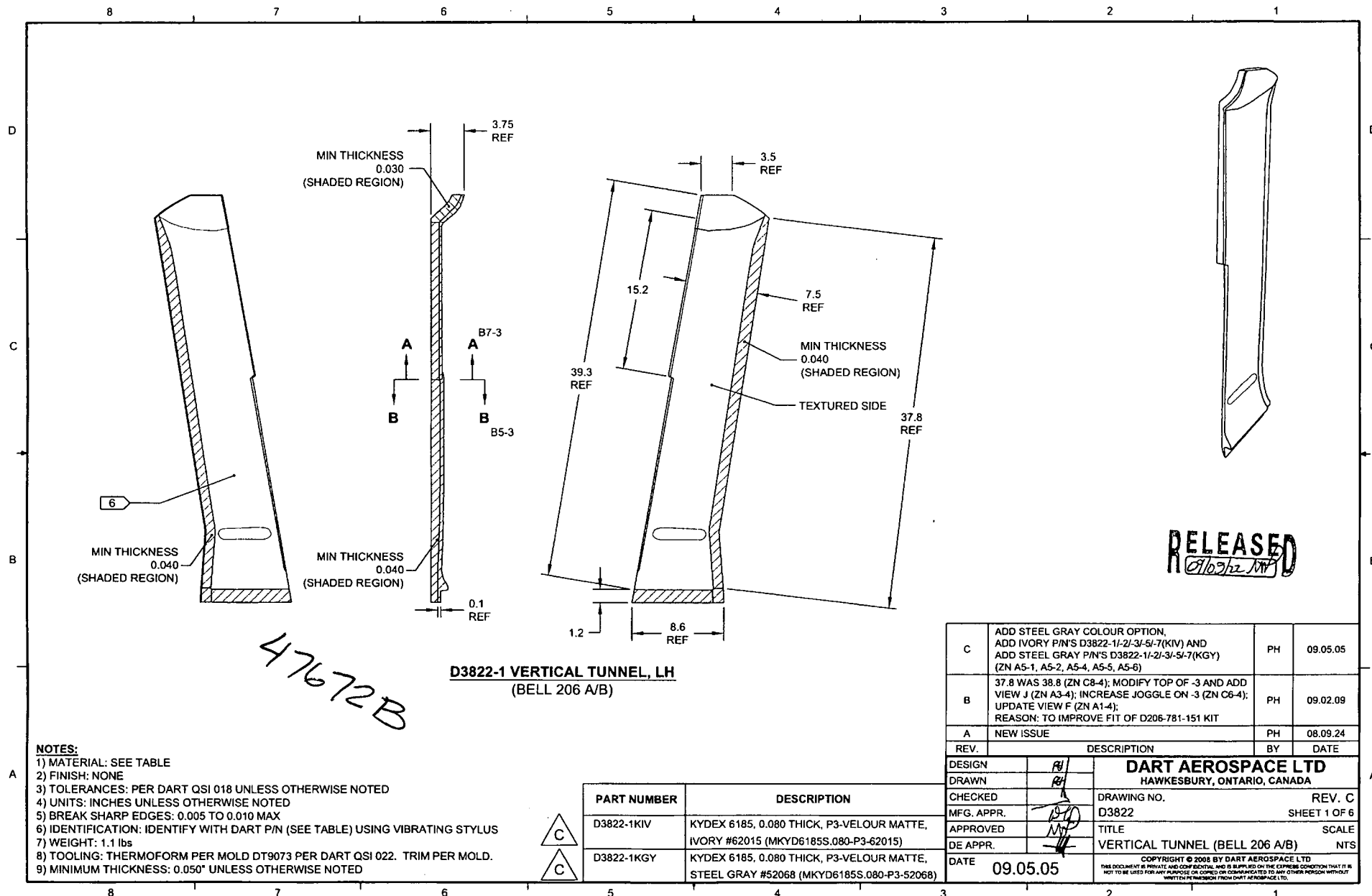
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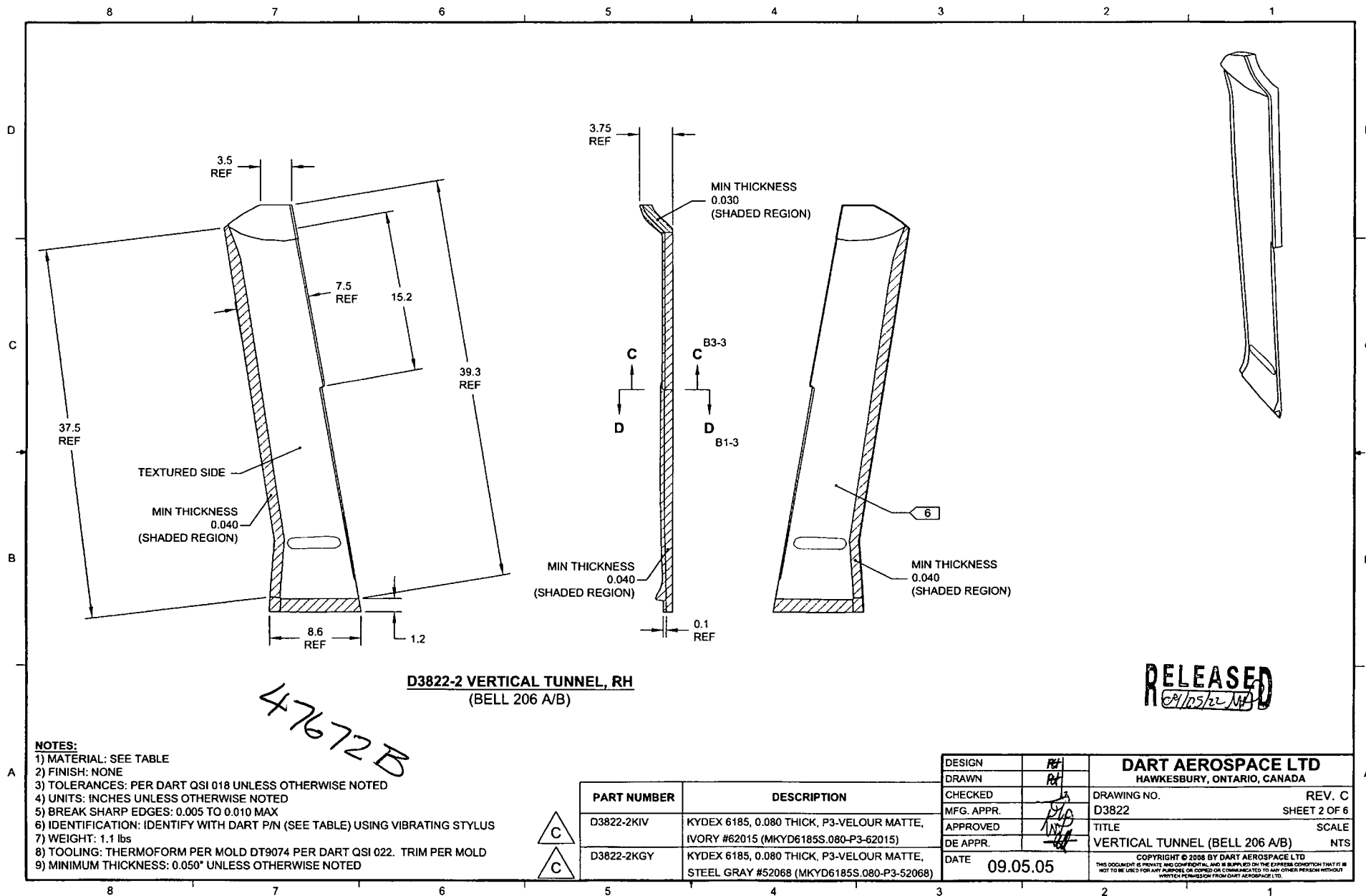
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DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3822	SHEET 4 OF 6
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DE APPR.	PH	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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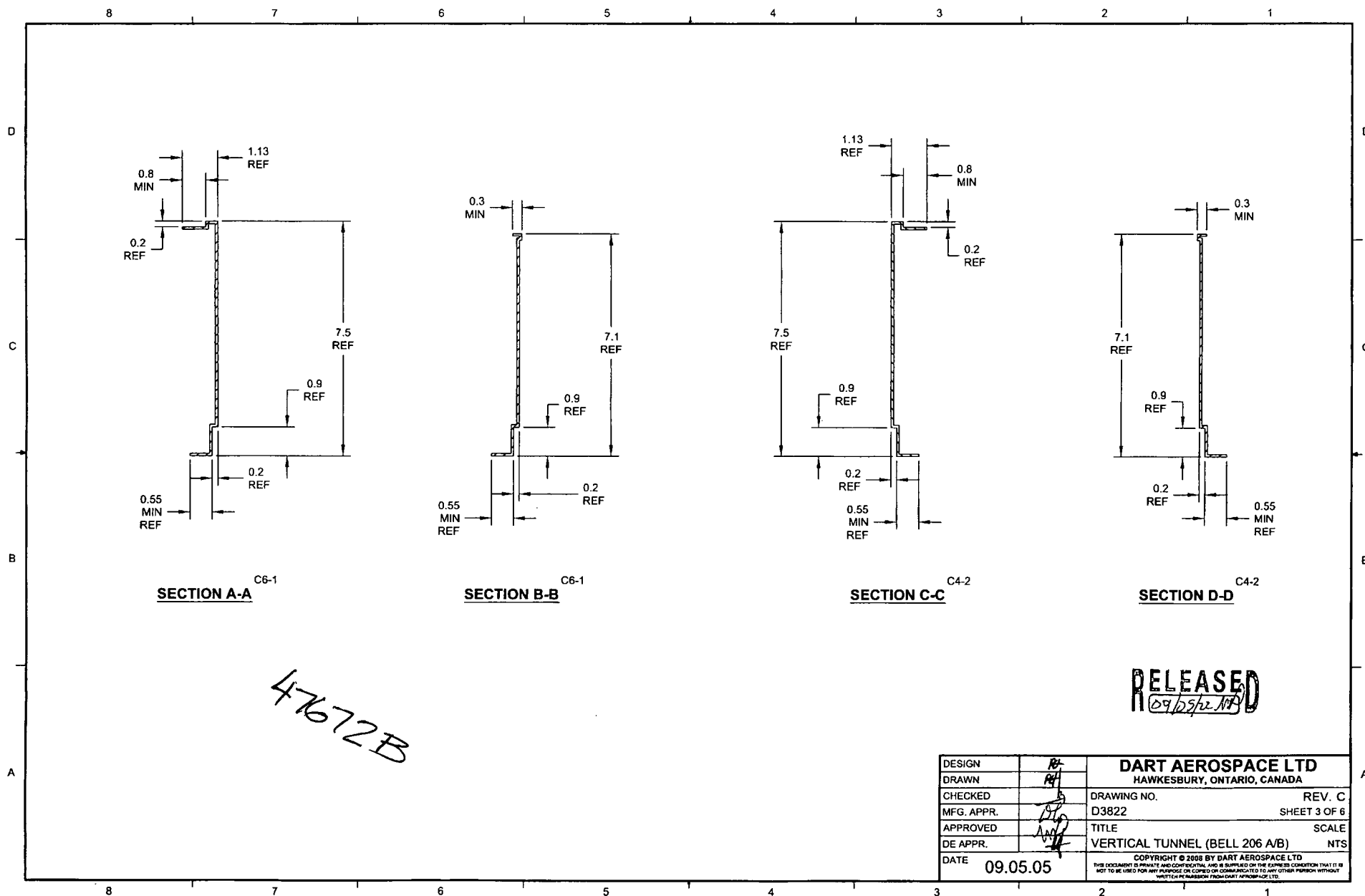
8 7 6 5 4 3 2 1











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CHECKED	RA	DRAWING NO.	REV. C
MFG. APPR.	RA	D3822	SHEET 3 OF 6
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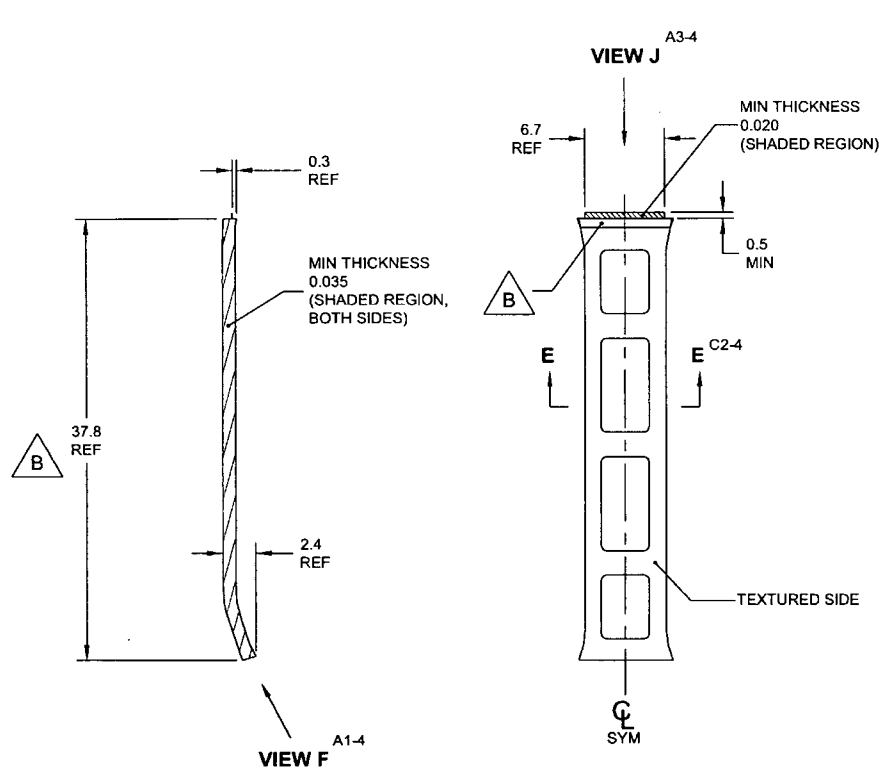
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D

C

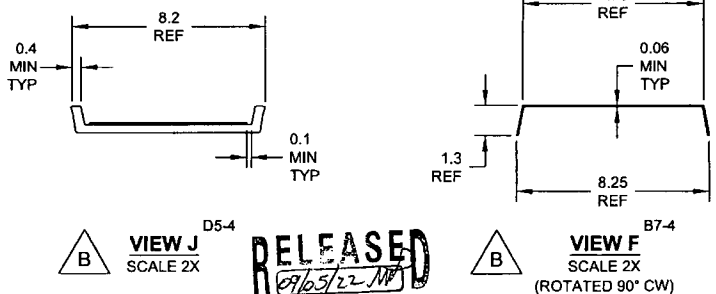
B

A



**D3822-3 VERTICAL TUNNEL, AFT CENTER**  
(BELL 206 A/B)

47672B



- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 1.1 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	REV. C
DRAWN	SHEET 4 OF 6
CHECKED	D3822
MFG. APPR.	TITLE
APPROVED	VERTICAL TUNNEL (BELL 206 A/B)
DE APPR.	SCALE
DATE	09.05.05
	NTS

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